

Work Order ID 84072

Wednesday, May 02, 2012 1:05:14 PM

84072

Page 1

Item ID: D3296-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly

Start Date: 5/2/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-05-2 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100 0.00
 100 Small Fab
 Small Fab Memo 0.00
 Small Fab Fabricate & assemble as per Dwg D3296.
 Transfer drill using DT8470 & DT9521

110 0.00
 110 QC QC5- Inspect part completeness to step on W/O
 QC Memo 0.00

120 0.00
 120 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3
 Powdercoat Memo 0.00
 Powder Coating

START TIME: FINISH TIME: OVEN TEMPERATURE:

32001- 2:00

M121279

6x 12/05/31

46

6x 12/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Work Order ID 84072

Wednesday, May 02, 2012 1:05:15 PM

84072

Page 3

Item ID: D3296-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 5/2/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/8/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

6x
 12-6-1
 12/6/4
 MF
 12-06-03

W/O:		WORK ORDER CHANGES					
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Wednesday, May 02, 2012 1:05:19 PM

Page 1

84072

D3296-041

Start Date: 5/2/2012**Required Date:** 5/8/2012**Start Qty: 12.00**

Required Qty: 12.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7		Manufactured	No			100	Each	1.0000	1	12			
D3161-7									**				
Hinge 14.0"													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST031				1					
				76938				1					
D3161-9		Manufactured	No			100	Each	0.0000	1	12			
D3161-9													
Hinge 17.0"													
D3296-1		Manufactured	No			100	Each	6.0000	1	12			
D3296-1									**				
Door Panel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233				6					
				75064				6					
D3296-3		Manufactured	No			100	Each	10.0000	1	12			
D3296-3									**				
Door Panel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233				10					
				75061				10					

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Picklist Print

Wednesday, May 02, 2012 1:05:19 PM

Page 2

Work Order ID: 84072

84072

Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 12.00

Required Qty: 12.00

MS20470AD4-6

Purchased

No

100

Each

3,552.000

1

12

MS20470AD4-6

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

3552

117395

16

118927

291

119109

12

120142

1233

121524

2000

D2137

Manufactured

No

140

Each

34.0000

1

12

D2137

Decal - No Step

**

Location

Loc Qty

Loc Code

GA

22

76064

2

79837

20

ST

12

108012

0

45851

0

52033

0

83540

12

D2419

Manufactured

No

140

Each

14.0000

1

12

D2419

Handle

**

Location

Loc Qty

Loc Code

GA

14

73717

8

80809

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, May 02, 2012 1:05:20 PM

Page 3

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Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 12.00

Required Qty: 12.00

D2462

Manufactured No

140 f

356.8004 0.3333 3.9998

D2462

Seal

**

PS 12/06/01

Location

Loc Qty

Loc Code

ST404

356.8004

48530

356.8004

140 Each

0.0000 0 0

D2728-1

Manufactured No

D2728-1

Dart Logo label

MS20470AD4-4

Purchased No

140 Each

4,478.000 25 300

**

**

PS 12/06/01

PS 12/06/01

MS20470AD4-4

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

4478

116188

136

116391

66

118614

1087

119109

26

120361

658

121011

505

121556

2000

NAS1149DN632J

Purchased No

140 Each

342.0000 1 12

NAS1149DN632.J

Washer

**

Location

Loc Qty

Loc Code

ST298

342

118428

342

PS 12/06/01

6

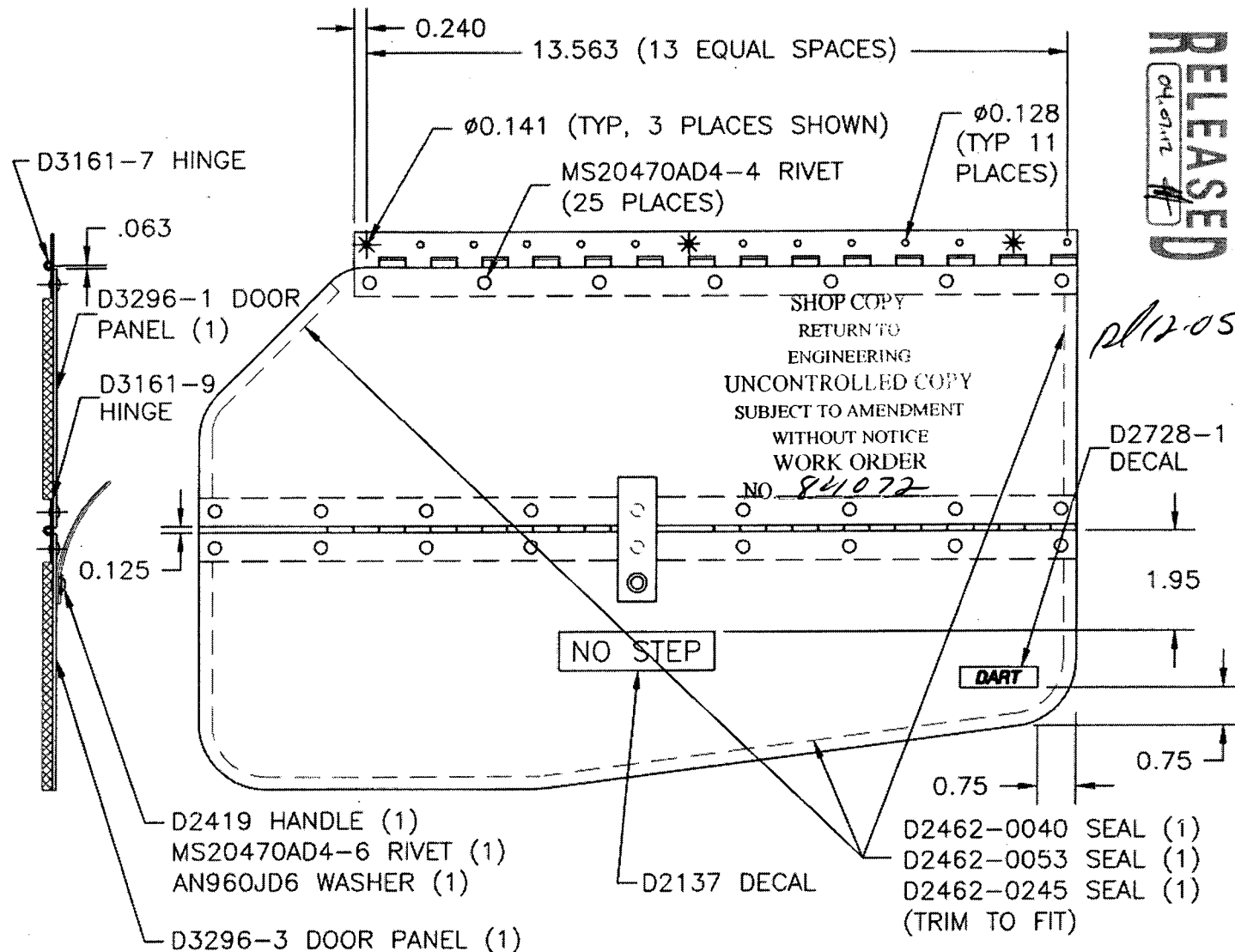
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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

2112-05-2

DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	APPROVED	UP	DRAWING NO.	REV. A
DATE	04.06.28			D3296	1 OF 2
				TITLE	SCALE
				DOOR ASSEMBLY	1:3
	A		04.06.28	NEW ISSUE	

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